Work Order I lugust-28-13 12:33.			J. 1.	*10F	3303*						Page 1	_
Revision ID:	938-2 Saddle	· .	***·	Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Star Sto	ΙΔ	S1*	
		4.00	444								.7/	
tart Date: 8/28	•	ty: 4.00	*4*		Cust Item 1	D:					,	
Required Date: 8/28	3/13 Req'd	<b>Qty:</b> 4.00	*4*	•	Customer:	i						
Reference:			). ·				_	T)	Stor			
approvals: Pro	ocess Plan:	-2	Date: 13-08-2	9 Tooling:	Da	ate:	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	N	lun Star	1/1	R1*	
QC	C:		Date:	_ SPC (Y/N):	Da	ate:	· 		Sto	*N	R2*	
equence ID/ Vork Center ID	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision Nb	r										
D2938	Rev C											
00				0.00					-			
*100*	HAAS CI	NC VERTICAL	MACHINING #1		ls.	2-09-0	4	4	Ø			
HAAS I	•	Memo		,0.00		<b>J</b>	•					
IAAS CNC vertical maci	nine #1	number are p	programmed correctly.2-	ber.1-Inspect part number a Machine Step No 1 of Foli I Dimension Sheet 3-Mach	io and visually							
			* *						•			
10				0.00		e.		٠, ١				
*11 <b>∩</b> *	CONVEN	ITIONAL MILI	LING MACHINE		<i>II</i>	3-09-1	Ç	4	Ø			
Mill Conv	•	Memo		0.00	MI	3-07-1	٥		7		i	
Conventional Milling Mad	chine	Machine Ke	yway and inspect per atta	sched dimension sheet					4			
	•				,							
		. 4	A A									
20	QC1- Insp	ect dimensions	to dimension sheet	0.00				. /				
*120*					S\$13-0	9 04	•	4	Ø			
QC .		Memo	•	0.00	2415-0	1-01						

Quality Control

DQA:	Date:

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	:
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap	Skid-tube Crosstube  Machining Small Fat			-1	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo				Use-as-is Work Order Update						
Root				Descr	iption of work order update	Initia	Ι Δ	Action	Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier											
Training Unapproved	$\dashv$									(	
опарргочец						AULT CA	TEGORY		.L		<u>.</u>
Landii	ng Gear				General						
	Bence Cente Crace Cruse Cuffs Heat Insperience Ripp Torq	re Not Conc ss ned/Crimpe	d in Tube ı Extrusio	-	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish	Insp Instr Mai Misl Misr Offs	lware ection Incomplete uctions Incomplete ntenance abeled ead	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Wave/Twist in Tube					ide Dimensions						

V	Jork	Orde	r ID	106	5303
٧,	<i>n</i> uin	Oluc		100	IJひむ

Work Ord  August-28-13 1		6303			*10		F						
Item ID: Revision ID: Item Name:	D2938-2 206 Saddle				Accept	*1	<b>1</b> 900	<u>040</u>	100	<b>)*</b> s	etup Star Stop	IV	S1* S2*
Start Date: Required Date: Reference:	8/28/13 8/28/13	Start Qty: 4.00 Req'd Qty: 4.00		*4* *4*			Cust Item II Customer:	<b>)</b> :					
Approvals:		an:			Tooling: SPC (Y/N):		Da			R	dun Star Stop	17	R1* R2*
Sequence ID/ Work Center I  130  *130* QC Quality Control	D	Operation Description QC8- Inspect parts - second Memo Chemical Conversion Conversion Conversion		5.4.1	Set Up/ Run Hours 0.00 0.00	7.0	Tool ID 13\09	Tool#	Plan Code	Accept Qty	Reject Qty	Reject ** Number	Insp. Stamp OAS 08 9-89
*140* HandFinish Hand Finishing		Memo	oat pei Qoioo	3 4.1	0.00					4	H	13	9:19
*150  *150* Powdercoat  Powder Coating		White Gloss(Ref:4.3.5.1)  Memo START TIM		17,5	0.00  Oven temperatur  Oven 2	RE:			L	1XP	MY	13/	04/19

W126125

				DQA:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		
				OA Closed:	

								-			QA Closed:	Date	e:	
Work Order					DISPOSITION				AGAINST	T DE	PARTMENT	PROCESS		
Part No.					Rework Scrap Use-as-is		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing		Ĺ	Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other	
NCR No	o	<u>.</u>			Work Order Update	ate Large Fab Composite Supplie						Supplier		
Root				Descri	ption of work order update	lr	nitial	Δ	ction		Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chi	ef Eng	Des	scription		Date	Verification		QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training														
Unapproved		<b>!</b>	<u> </u>			<u> </u>	r cate	CORV			1		1	
Landin	a Goor				General r	AULI	CATE	GORT						
	Bending Centre No Cracks Crushed/ Cuffs	Crimped	ntric to (	o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	on Incomplete ions Incomplete nance	e/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ssing	Te W	essure/Forced mperature/Cure eld rong Stock Pulled
-	Heat Trea			-	Countersink	$\vdash$	Mislabe			$\vdash$	Positioned W		٦.,	
-	Inspectio	-	iube	-	Cut Too Short	Н	Misread	1		<u></u>	Power Loss/	ourge	Jut	her
-	Ripples in			. ⊢	Drill Holes	-	Offset	Calibration						
-			s in Extrusion Drawing				Out of Calibration Out of Sequence							
	Turning S Wave/Tw	•	<del></del>				Outside Dimensions					·		
	[wave/Iw	กระเทาเนเ	Je	I	ורטווט	1 1	Juisiae	Dimensions						

Date: \_

Work	Order	ID	106303
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# \*106303\*

Page 3

August-28-13 12:33:22 PM Item ID: D2938-2 Accept \*N900040100\* Setup Start **Revision ID:** Stop 206 Saddle Item Name: \*4\* Start Qty: 4.00 **Start Date:** 8/28/13 **Cust Item ID:** Req'd Qty: 4.00 Required Date: 8/28/13 \*4\* **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Insp. Tool # Plan Accept Reject Reject Description Work Center ID Qty Number **Run Hours** Code Qty Stamp 160 QC3- Inspect Part Finish 0.00 \*160\* 0.00 Memo Quality Control Identify as per dwg & Stock Location \$\frac{1}{3}\$ 170 \*170\* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 \*120\* QC 0.00 Memo Quality Control

NB-09-3-3

NCR:	Yes	/	No

DQA: \_\_\_\_ Date: \_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	LUNFUE	(IVIAINCE / UF	PDATE	QA Closed:	Dat	e:
Work Order	·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. S					Rework Scrap		Skid-tube Crosstube Wate  Machining Small Fab Prod. Eng. C				Engineering Quality
NCR No	0				Use-as-is Work Order Update	Thermoforming Finishing Rec/Store/Packaging Supplier					Other
Root				Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
oc/Data					,						
quip/Tooling								•			
perator											
/laterial	_										
etup											
Other	_					ŀ					
rocess			ļ								
upplier											
raining											
Inapproved										<u> </u>	
7.			_		<u>F</u>	AULT CAT	EGORY				
Landin	g Gear				General				-	-	<u> </u>
*33	Bending				Bend	Grain	1		Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (	D/S	BOM/Route	Hardy	vare	<u></u>	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed/	'Crimped			Burrs	Instru	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
Ī	Heat Tre	at			Countersink	Misla	beled		Positioned V	Wrong _	
	Inspection	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	/Surge	Other
Ī	Ripples in	n Bend			Drill Holes	Offse	t				
	Torque V	Vaves in E	Extrusion	,	Drawing	Out o	f Calibration				
ľ		Sequence			Finish	Out o	f Sequence				
	Wave/Tv	vist in Tul	be		Folio	Outsi	de Dimensions				

## Picklist Print

August-28-13 12:33:26 PM

Work Order ID: 106303

\*106303\*

Parent Item:

D2938-2

\*D2938-2\*

Parent Item Name: 206 Saddle

**Start Date: 8/28/13** 

Required Date: 8/28/13

Start Qty: 4.00

Required Qty: 4.00

**Comments:** 

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	50.0000	1	4			
*D6404 00	<b>10</b> *								**				

\*D6101-003\*
Saddle Billet, 7075

<b>Location</b>	Loc Qty	Loc Code		
MAT042	16			
<b>&gt;</b> 102142	10			. ما مدا ساحا
<b>4</b> 103592	6		<b>T</b>	Pt. 13/09/01
MAT045	34			
97563	34			

Page 1

DQA: Date:

		,	
NCR:	Yes	/	No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

3

NCA. 1	es / 140				WORK ORDER HOR		(IVIAITOE / O		QA Closed:	Date	2:
Work Orde	r.			1	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOLK GIGE	· ·			•	Rework	1	Skid-tube	Crosstube	1	Water Jet	Engineering
Part No	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	The	rmoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update	]	Large Fab	Composite	]	Supplier	
Root		I		Descri	ption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	scription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling				*		İ					
Operator						1.					
Material											
Setup										:	
Other				•						<u> </u>	
Process											
Supplier						1					
Training											
Unapproved											
					F.	AULT CAT	EGORY				
Landin	g Gear				General				-	<b>,</b>	
	Bending				Bend	Grain	1		Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	_BOM/Route	Hard	ware	<u> </u>	Over/Under	tolerance	Temperature/Cure
L	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ictions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved		
Γ	Heat Trea	at	•		Countersink	Misla	beled		Positioned V	Vrong	_
Ī	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	Surge	Other
Ī	Ripples in	n Bend			Drill Holes	Offse	t		- 		
Ì	Torque V	Vaves in I	Extrusio	n	Drawing	Out o	f Calibration				
Ī	Turning S				Finish	Out o	f Sequence				
ľ	Waye/Tu				Teolio	Outsi	de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

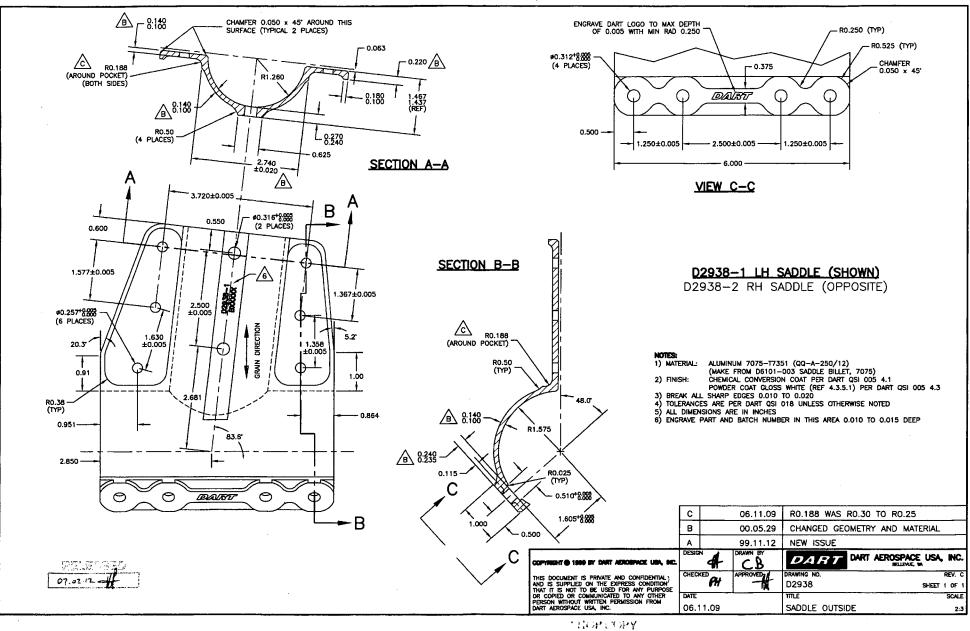
DART AEROSPACE LTD	Work Order:	106303
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		114	,116	0119	6119		
В	0.100	0.140		114	ille	6116	114		
С	0.100	0.140		115	6118	-119	.120		
D	0.210	0.230		·210	2221	0221	. 220		
Е	1.245	1.255		1.248	1.248	L248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1-248		
G	2.495	2.505		2.498	2.498	2.498	2.498		
Н	0.510	0.515		45/3	.513	1513	« S/3		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.496	2.498	2.499	2.499		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	. 314	.314	.314		
M	0.235	0.240		, 2385	.2385	2385	-2385		
N	0.100	0.140		2118	0119	اار	61185		
0	0.540	0.560		.546	.546	. S44	,544	•	
Р	0.490	0.510		.501	o 499	.494	1496		
Q	3.715	3.725		3.716	3,718	3.717	3.717		
R	2.720	2.760		2.741	2,740	2.740	2.740		·
S	0.240	0.270		0240	, 251	.251	. 251		
Т	0.100	0.180		e 140	6140	2140	.146		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.347	1.346	1.366	1.367		
W	0.316	0.321		31k	باآذ	.316	.316		
Х	1.250	1.270			1.261	1.261	1.261		
Υ	1.565	1.585		1.2605	1.574	1.574	1.5735		
Z	0.178	0.198		188	.188	.188	.188		
AA									
AB									
AC									•
AD						1			
AE									•
AF									····
AG									
AH				1.					
	Ace	ept/Reje	ct						

Measured by:	Audited by	K.A	DAG.
Date: 13-09-03	Date:	13/09/18	08

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	-1
С	07.03.21	Revised per drawing revision C	KJ/JLM A	



THEN CORY
THEN TO
THEN TO
THE STEPLING
FINCES TO NOW ENT
TO THE STREET
TO 6303 MCT
13-08-29